

Work Order ID 125914

December-01-14 9:12:11 AM

Report
125914 *Push!*

Page 1

Item ID: D3793-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Fwd
 Start Date: 11/03/14 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 11/21/14 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3793	Rev A

100 FLOW WATER JET 0.00 ***100*** *(50)* Dec 14/12/09 DAS 23 9-89
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3793 Dwg Rev: A Prog Rev: A 2-
 Deburr if necessary
304.040

110 QC2- Inspect parts off machine FAI/FAIB 0.00 ***110*** *(51)* Dec 14/12/09 DAS 23 9-89
 QC Memo 0.00
 Quality Control

120 QC8- Inspect parts - second check 0.00 ***120*** *(51)* DEC 09 2014 DAS 38 9-89
 QC Memo 0.00
 Quality Control

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	NC BRAKE	0.00							
130									
Brake NC	Memo	0.00			DAS 30 9-89	51			
Brake NC	1-Deburr if necessary2-Form on Brake as per Dwg D3793 using Jigs 3-Form Joggle on brake using Jig as per Dwg D3793						DAS 28 9-89	DEC 10 2014	

14/12/10

140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

51

DAS
38
9-89
DEC 10 2014

150	Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 7:40 FINISH TIME: 8:10 OVEN TEMPERATURE:								

m 128064.

51 14-12-18. 238

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Page 3

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>FP-002</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

5/1 f ll 11/12/19 **DAS 15 9-89**

x51 f ll 11/12/22

15/1/59

14-12-22



Picklist Print

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Work Order ID: 125914

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Parent Item: D3793-1

D3793-1

Parent Item Name: Wearplate Fwd

Start Date: 11/03/14

Required Date: 11/21/14

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

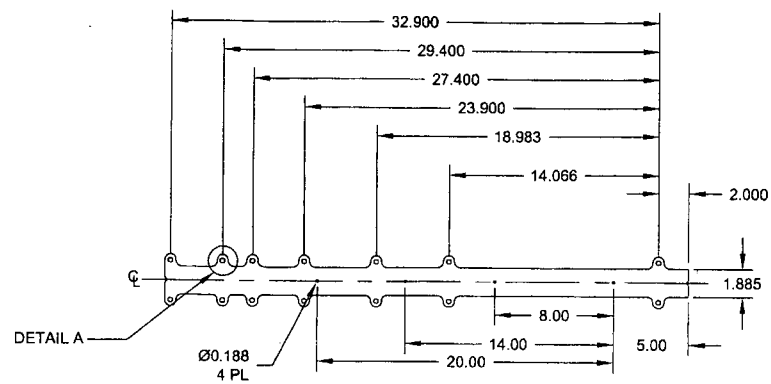
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	219.6072	0.5902	32			
M304S20GA											DAS		
304/316 .040 Sheet											23		
											9-89		

DC 14/12/09

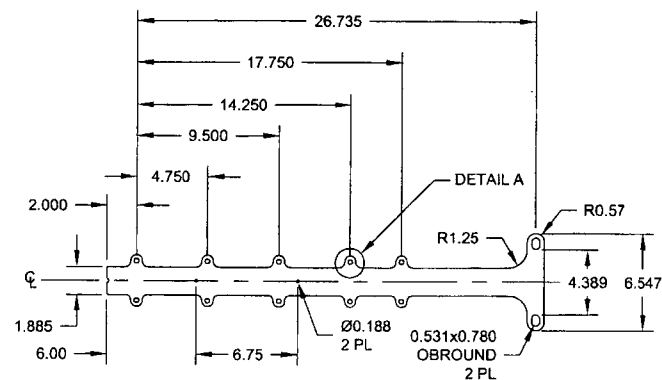
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	219.6071948	
m126852	0.31	
m127454	26.1018948	
m128435	81.14	
m129845	28.89	
m130345	1.1319	
m130745	82.0334	
131060		

(48)

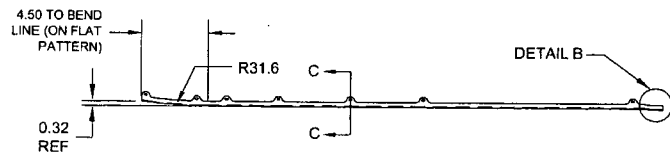
8 7 6 5 4 3 2 1



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

RELEASED
080523/16

NOTES:

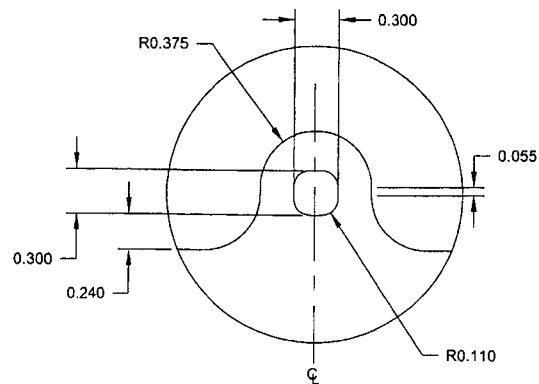
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

A NEW ISSUE		PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3793	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	NTS
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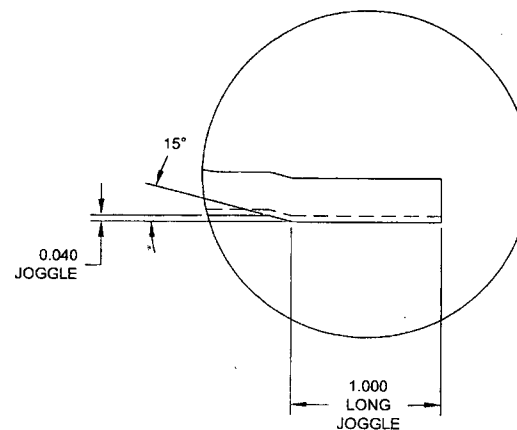
8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D



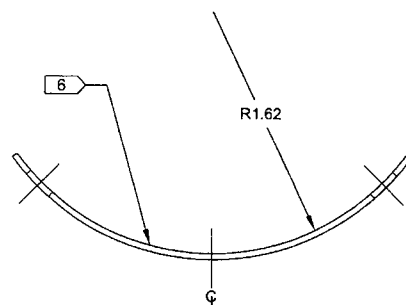
DETAIL A
SCALE 10X



DETAIL B
SCALE 10X

C

B



SECTION C-C
SCALE 10X

RELEASED
08-05-14

A

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3793	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	NTS
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8 7 6 5 4 3 2 1